

Date: Wednesday, 6/6/2007 1:58:04 PM  
User: Kim Johnston

# **Process Sheet**

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE BLOCK
Job Number	: 32797		
Estimate Number	: 10324		
P.O. Number	:	Part Number	: D1049
This Issue	: 6/6/2007 S.O. No. :	Drawing Number	: D1049 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1 / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 29770	Material	:
Written By	:	Due Date	: 7/1/2007 Qty: 50 Um: Each
Checked & Approved By	: <u>9/10/06/07</u>		
Comment	: Est RevC 02.04.10 Re-format NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0750X00250	6061-T6 Bar .750 x .250
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Comment: Qty.: 0.1749 f(s)/Unit Total: 8.7465 f(s)  
Material: 6061-T6 bar .750 wide x .250 thick.  
Batch M19380

J.L 07/11/02

2.0	SHEAR	SHEAR
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Comment: SHEAR  
Cut Blanks: 2.000" long

J.L 07/11/02

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
  
1-Machine as per folio FA217 & Dwg D1049  
  
2-Deburr

DJP 07/12/14

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DJP 07/12/14

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SE 07.12.14

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BLOCK

Job Number: 32797

Part Number: D1049

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HL 07-12-17

(X50)

7.0

POWDER COATING

POWDER COATING



M100700



(50X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M-1

07/12/17

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

HL 07/12/17

(50)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST2

HL

08/12/18

(X50)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



HL 2007/12/18

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

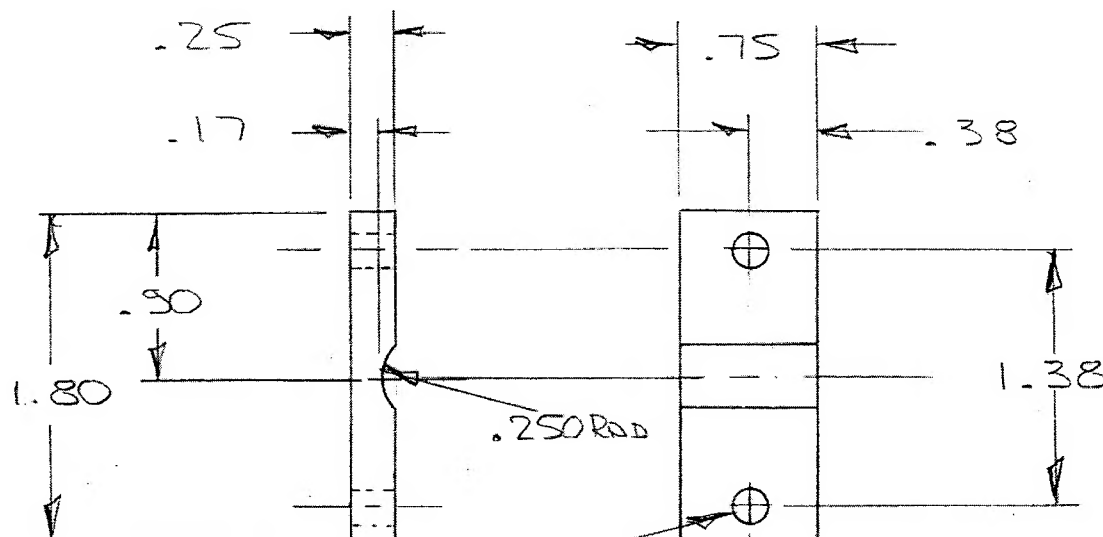
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED  
97/09/02 BW



.203 DIA.  
TYP

MATERIAL : S052-H32

FINISH : POWDER COAT

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 32747



REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
DRAWN			BASIC CODE	DIA. DASH NO. W-HEAD NEAR SIDE F-HEAD FAR SIDE	CONTRACT NO.		<b>DART</b> DART AERO ACCESSORIES INC. VANCOUVER CANADA		
APPROVED			D-DIMPLE DIGIT-NO OF SHEETS C-COUNTERSINK	LENGTH DASH NO. W-SPOTWELD	DRAWN 14247	DATE MAY 17 1992			
DESCRIPTION OF CHANGE	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED		BASIC CODES		STRESS		TITLE SADDLE		
	GENERAL	UNITS	8J-ME2047040 BB-ME2047260		CHECKED		CODE		
	1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS .010 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER NAS - 8 - 7742 5. HOLES PER AND 10347	1. TOLERANCES — JXX & .000 KXX & .010 2. ANGLES & 90° 3. PARALLELISM & .0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005			CLIENT		DWG NO. D1049		REV.
REPORT ALL DISCREPANCIES — DO NOT SCALE									